

Date: Wednesday, 1/24/2007 4:50:20 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206B FWD X-TUBE  
 Job Number : 30439  
 Estimate Number : 12346  
 P.O. Number : *N/A* Part Number : D206667101  
 This Issue : 1/24/2007 S.O. No. : *N/A* Drawing Number : D206-667-141REV B  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : *N/A* Type : LANDING GEAR Drawing Revision : B  
 Previous Run : 30438 Material : *N/A*  
 Written By : Due Date : 2/28/2007 Qty: 1 Um: Each  
 Checked & Approved By : *07.01.25*  
 Comment : Est Rev: F 05.09.01 Add holes for compatibility with Bell  
 Skid tubes KJ/JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-101 CHG002

2.0 D6001105 Crosstube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6001-105 Crosstube *B26551*

Check OD = 2.250"; ID = 1.874"

3.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA083

2-Turn first side as per Folio FA083

3-Deburr & Inspect for surface damage.

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA083

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-141.

3-Remove sand and plugs

4-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-141

Inside of Cuff(Donot engrave on outside of tube)

*9mk 07/02/04*

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

*9mk 07/02/04*

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*SD 07.02.05*

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

*9mk / R 07-02-08*

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*9mk / R 07-02-08*

10.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-141 using CNC bender program 206B-fw and Folio FT

*ELP 7-2-9*

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

*9mk 07-02-08*

W/O:		WORK ORDER CHANGES					
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Part Number: D206667101

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

- 1-Drill pilot holes in tube using drill Jig DT8541 & DT8542 as per Dwg D206-667-141. Drill all (3) top holes.
- 2-Drill & ream holes as per Dwg D206-667-141 using drill Jig DT8575 & DT8576. Drill all (3) top holes.
- 3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.
- 4-Drill pilot holes using drill Jig DT8541 & DT8542 as per Dwg D206-667-141. Drill only the top (2) holes.
- 5-Drill pilot holes as per Dwg D206-667-141. Drill only the top (2) holes.
- 6-Drill Fwd rivet holes using drill Jig DT8787FWD as per Dwg D206-667-141.  
Note: Fwd side has 3x top holes.
- 7-Drill Aft rivet holes using drill Jig DT8787AFT as per Dwg D206-667-141.
- 8-C'sink holes as per Dwg D206-667-141. Allow rivet to sit below surface to compensate for paint.
- 9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-141

07-03-13

507-3-13

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

507-3-13

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-03-28

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-03-28

16.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: 3440 LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

0201/03/28 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 30439

Part Number: D206667101

Job Number:



Seq. #: Machine Or Operation: Description :

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

C207/03/30 (1)

18.0

QC6

DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

20703-30  
20703-30

(1)

19.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2.1

\*\*\*\*\*Let tube sit up right for 30mins before hanging\*\*\*\*\*

P4500-P-23 Base Batch: 104180

P4500-C-23 Catalyst Batch: 104180

Start time: 7:00

Finish: 12:00

} RT  
07-05-30

20.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

20705-30 (1)

21.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Paint outside crosstube with White Imron as per QSI 005 4.2

Imron 55U white paint

Batch: 1104045

Imron 125S activator

Batch: 104975

Start: 8:30

} RT 07-05-30

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

*1807-06-01*

23.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2138 f(s)/Unit Total: 1.2138 f(s)

Pick:

Qty Part number Description Batch  
2 D2856-400(Cut to 6.94") Abrasion Strip

*32020*

*RT 07-06-25*

24.0

D2873043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch  
2 D2873-043 Nut Plate

*30449*

*RT 07-05-70*

25.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch  
2 D2873-045 Nut Plate

*29852*

*RT 07-05-70*

26.0

D28911

Support 2.25 dia



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch  
2 D2891-1 Support

*26715/28077*

*RT 07-06-25*

27.0

MS20601AD4W8



Comment: Qty.: 14.0000 Each(s)/Unit Total: 14.0000 Each(s)

Pick:

Qty Part number Description Batch  
14 MS20601AD4W8 Rivet

*102850*

*RT 07-05-70*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 30439

Part Number: D206667101

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-20

Clamp

102712

85 07-06-25

29.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8579. .Note: (3) top holes should be facing up.

2-Install supports and clamps as per Dwg D206-667-141. Torque clamps to 80-100 in lb.

3-Install nut plates as per Dwg D206-667-141. Touch-up rivet heads with Imron paint.

85 07-06-25

85 07-05-30

30.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

31.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

32.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch:

M15072-

33.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch:

M103446-

85 07-16-26 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 9/18/27  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 30439

Part Number: D206667101

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

AN57A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part number

Description Batch

10 AN5-7A

Bolt

1100828 -

35.0

AN530A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part number

Description Batch

4 AN5-30A

Bolt

1102473 -

36.0

AN960JD516

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick: Packing Kit

Qty Part number

Description Batch

18 AN960JD516

Washer

1103694 -

1/27/06/260

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

1/27/06/260 11041260

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-687-101

Location: e

PPP Rev: e

1/27/06/260

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

1/27/06/260

Job Completion



1/27/06/260

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 30439
<b>Description:</b> Crosstube Assembly (206B High Fwd)		<b>Part Number:</b> D206-667-141
<b>Inspection Dwg:</b> D206-667-141 <b>Rev:</b> B		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

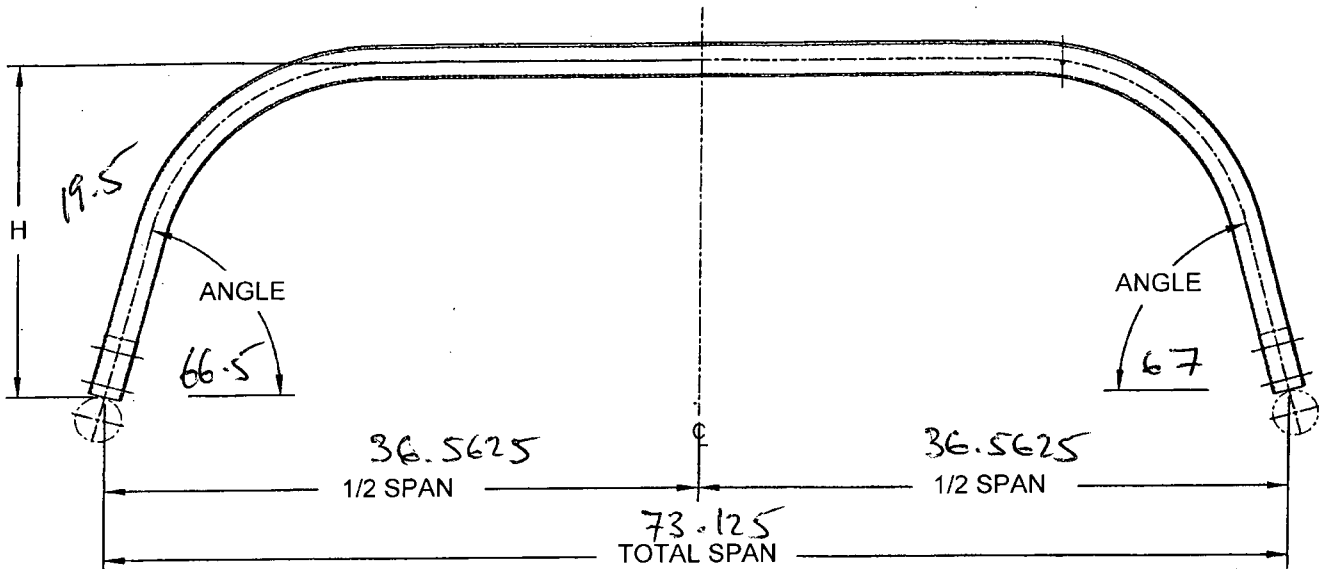
☒ First Article
 ☐ Prototype

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.241	—			
	2.074	+0.005/-0.000	2.077	—			
	2.074	+0.005/-0.000	2.079	—			
	2.114	+0.005/-0.000	2.118	—			
	2.154	+0.005/-0.000	2.158	—			
	2.194	+0.005/-0.000	2.199	—			
	2.234	+0.005/-0.000	2.239	—			
	0.110	+/-0.010	0.118	—			
	0.300 x 30°	+/-0.010	0.300x30°	—			
	R0.063	+/-0.010	R0.063	—			
	R0.500	+/-0.010	R0.500	—			
	4.438	+/-0.030	4.438	—			
SIDE B	2.240	+0.005/-0.000	2.241	—			
	2.074	+0.005/-0.000	2.078	—			
	2.074	+0.005/-0.000	2.079	—			
	2.114	+0.005/-0.000	2.118	—			
	2.154	+0.005/-0.000	2.158	—			
	2.194	+0.005/-0.000	2.199	—			
	2.234	+0.005/-0.000	2.239	—			
	0.110	+/-0.010	0.116	—			
	0.300 x 30°	+/-0.010	0.300x30°	—			
	R0.063	+/-0.010	R0.063	—			
	R0.500	+/-0.010	R0.500	—			
	4.438	+/-0.030	4.438	—			
	93.18	+/-0.020	93.180	—			

<b>Measured by:</b> <i>ML</i>	<b>Audited by:</b> <i>SD</i>	<b>Prototype Approval:</b> N/A
<b>Date:</b> 07/02/04	<b>Date:</b> 07.02.05	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A	06.10.24	New Issue (P/O D206-667-101)	KJ/JLM <i>AK</i>	<i>BE</i>

# Crosstube Bend Dimension Sheet



Height is even ✓

PART NUMBER: 206-664-101

BATCH NUMBER: 30439

DRAWING: 411 REVISION: B

H: 19.54 ✓

1/2 SPAN: 36.6

TOTAL SPAN: 73.2

ANGLE: 65<sup>+2</sup><sub>-0</sub> ✓

QC 15:

DATE: 07

QTY: 1





DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED HDS	APPROVED HDS	DRAWING NO. D206-667-141	REV. B SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206B HIGH FWD) NTS	
A	00.11.17	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED  
05.07.26

UNDER REVIEW  
06.08.10 PH  
re.dwn detail F  
PH  
07.01.25

Qty	Part Number	Description
X	D206-667-141	CROSSTUBE ASSEMBLY (206B HIGH FWD)
1	D6001-105	CROSSTUBE
2	D2856-400-694	ABRASION STRIP
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2891-1	SUPPORT
14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
4	MS21920-20	CLAMP

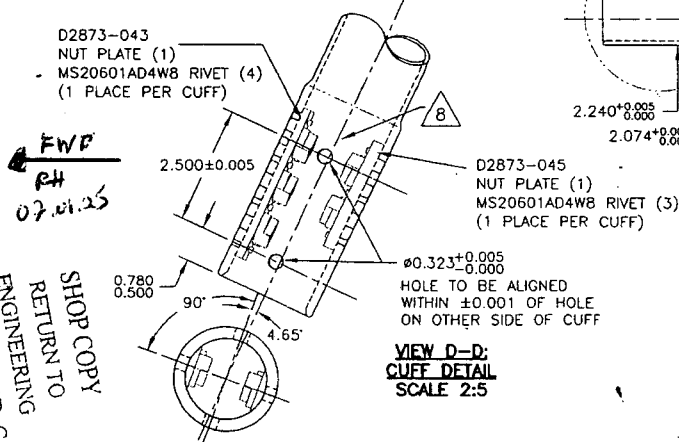
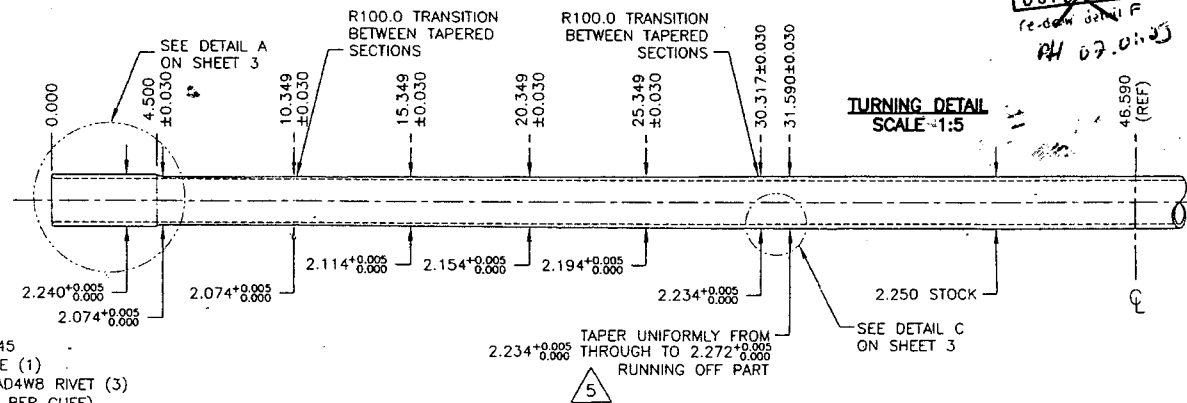
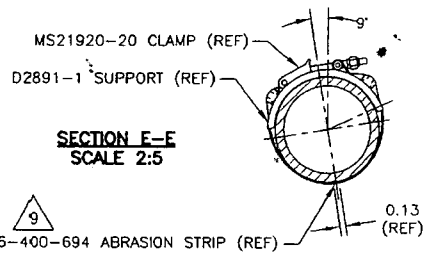
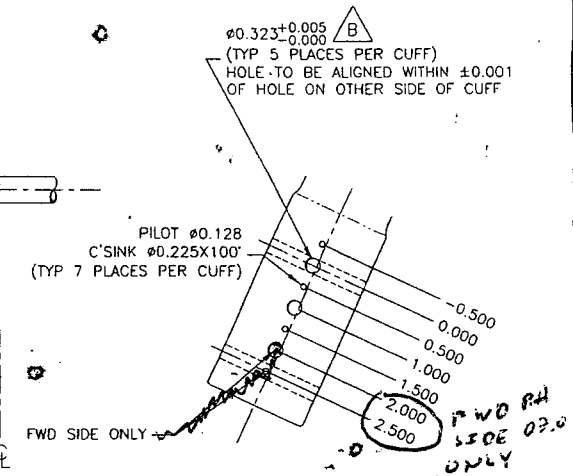
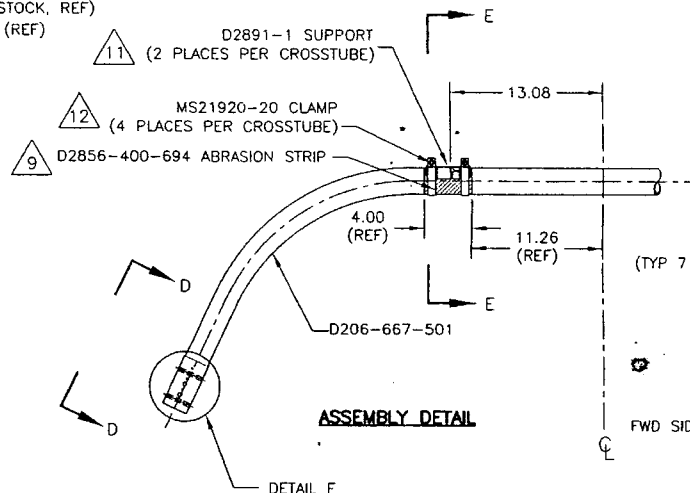
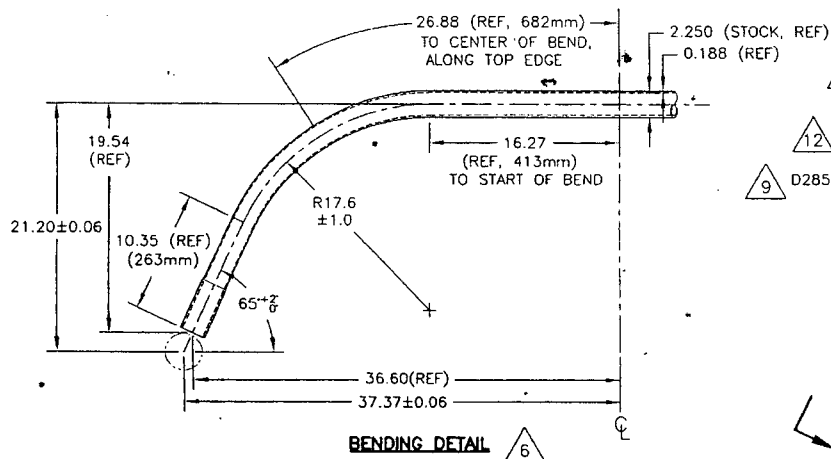
#### GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6001-105  
FINISHED LENGTH = 93.18±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 12 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-694 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2891-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX 241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30439

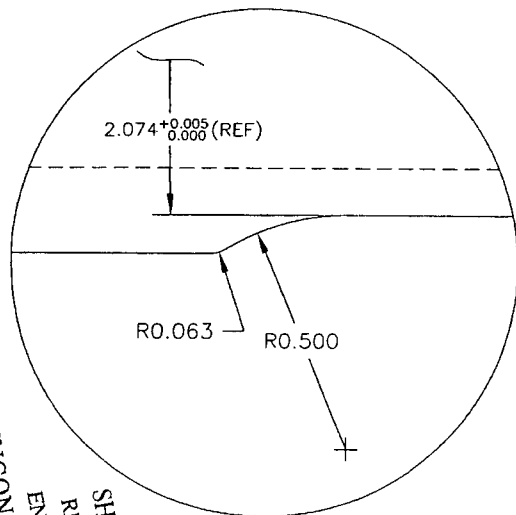
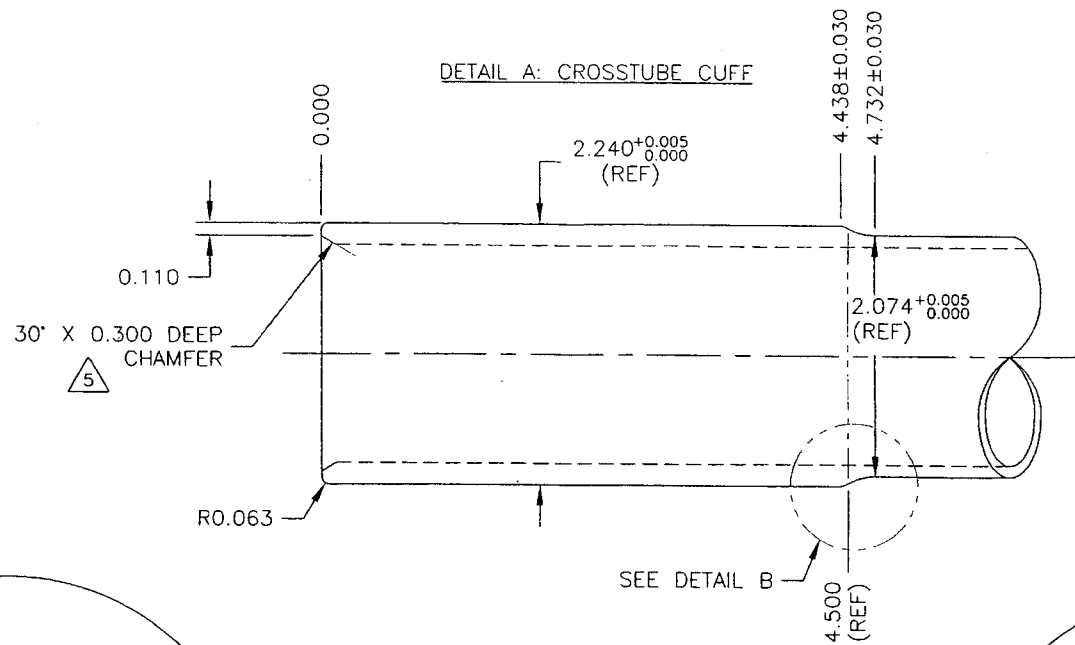
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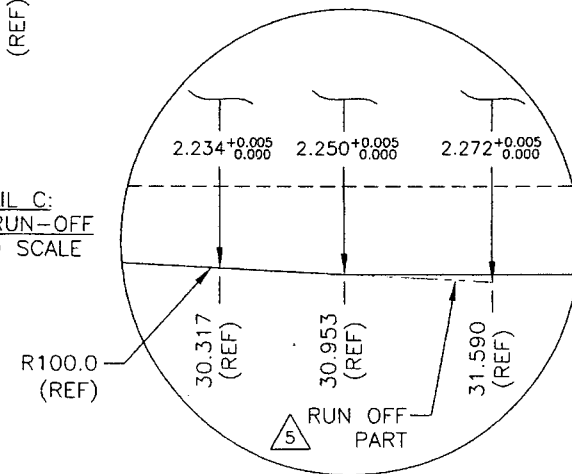


NO. 201739  
 WORK ORDER  
 SUBJECT TO AMENDMENT,  
 UNCONTROLLED COPY  
 RETURN TO  
 SHOP COPY  
 07.01.25  
 FWD  
 PH

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DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206B HIGH FWD)		SCALE 1:10	



DETAIL C:  
TAPER RUN-OFF  
NOT TO SCALE






UNDER REVIEW

06.03.25 PH  
re-BW AD-1 F

PH  
07.01.25

05.07.26

NO. 304139  
WORK ORDER  
WITHOUT NOTICE  
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		CHECKED 	APPROVED 	DRAWING NO. D206-667-141	REV. B SHEET 3 OF 3
		DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206B HIGH FWD)	SCALE 1:1





# HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3  
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 36061

A.M.O. Number: 46/90

## NON-DESTRUCTIVE TESTING REPORT

### AIRCRAFT / COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

### INSPECTION REQUIREMENTS

Carry out FPI of seven (7) cross tubes (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty. (2) P/N D412-664-145 S/N's B31137 & B31138

Qty. (1) P/N D206-667-103 S/N B30428

Qty. (2) P/N D412-664-203 S/N's B30427 & B30425

Qty. (2) P/N D206-667-101 S/N's B30439 & B30437



RADIOGRAPHY



ULTRASONIC



PENETRANT



MAGNETIC PARTICLE



EDDY CURRENT

### INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on seven (7) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)  
Ardrox 970P25E Batch #04B503.

Seven (7) cross tubes PASSED inspection.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH  
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY: 

DATE March 29, 2007

INSPECTION  
STAMP(S) Not Required

### CUSTOMER INFORMATION

CUSTOMER: Dart Aerospace

P.O. NUMBER

3440

ADDRESS:

CONTACT NAME:

LABOUR	@	\$
MATERIALS	@	
TRAVEL EXPENSES	@	GST
HOTEL EXPENSES	@	PST

INVOICE NO.

TOTAL \$

WHITE COPY - INSPECTION FILE • YELLOW COPY - CUSTOMER • PINK COPY - ACCOUNTANT